

Date:

Wednesday, 10/11/2006 12:50:38 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Type

Job Number **Estimate Number** : 28944

: 11160

: 25622

P.O. Number

· 44

: 10/11/2006 This Issue

: NC Prsht Rev. : NA First Issue

Previous Run

Written By

Comment

Checked & Approved By

: Est:

Total:

: MACHINED PARTS

New issue KJ/RF

S.O. No. : N/

: FITTING **Drawing Name**

Part Number Drawing Number : D32571 : D3257 REV A1

Project Number **Drawing Revision**

: N/A

Material

: 10/26/2006 **Due Date**

Qty:

8 Um:

Fach

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M303B0500X0500 1.0

AISI 303 Bar .5 x .5

0.9173 f(s)

Comment: Qty.: 0.1147 f(s)/Unit

AISI 303 Bar .5 x .5 Material: AISI 303 SS Bar (M303B0.500x0.500) Identify for D3257-1

Batch: M17625

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank: 0.500" x 0.500" x 1.180" long Bar

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Deburr



Machine as per Folio FA420 and Dwg D3257

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

R

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	GES				······································
DATE STEP		PR	PROCEDURE CHANGE By			Dat	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Y	es No	DQA:	D Date: ∠	6/18/23
					Q.	A: N/C CI	osed:	_ Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC	Description of NC Corrective Action		Section B		erification	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	SiQ D	in & ate	Section C	Chief Eng	QC Inspector
							.		

NOTE: Date & initial all entries

Date:

Wednesday, 10/11/2006 12:50:39 PM

Kim Johnston User:

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 28944

Part Number: D32571

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location 5

7.0

QC21





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



('Lac110123

Dart Aerospace Ltd

DuitAc	, ospao	C Ltd							
W/O:			WC	RK ORDER CHAN	GES			•	· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						•			
Part No):	PAR #:	Fault Cated	iorv:	NCR: Yes	No DQ	 A:	Date:	
								Date: _	
NCR:			WORK ORDE	R NON-CONFORM	MANCE (NC	R)			
DATE	STEP	Description of NC	Description of NC		ection B		cation	Approval	Approval
	J. 2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
	,								
		,							
			·						

NOTE: Date & initial all entries

DART AEROSPACE LTD

Description: Fitting

Part Number: D3257-1

Inspection Dwg: D3257 Rev: A1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.127				
0.135	+0.010/-0.007	0.128	/			
1.080	+/+0.010	1.083				
0.330	+/-0.010	0.228	/			
0.385	+/-0.010	0.389	-			
Ø0.191	+0.005/-0.000	80.191	_			
R0.193	+/-0.010	RO.193				
0.887	+/-0.010	0.884	_			
0.385	+/-0.010	0.390	_			
0.192	+/-0.005	0.195	/			
Ø0.230 x 100°	+/-0.010	80.232×108	~			
0,135	+0.010/-0.007					
	:					
419.4						
					<u> </u>	

Measured by:	Inl	Audited by:	ir	Prototype Approval:	N/A
Date:	06/10/20	Date:	06/10/20	Date:	N/A

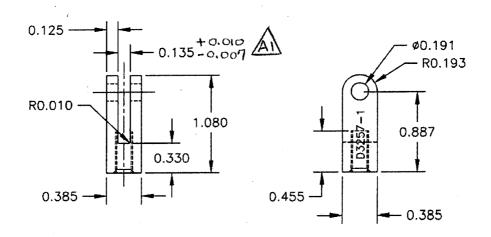
Rev	Date	Change	Revised by	Approved
Α	04.12.10	New Issue	KJ/JLM LA	1
В	05.06.20	0.455 dimension removed	KJ/JLM of	

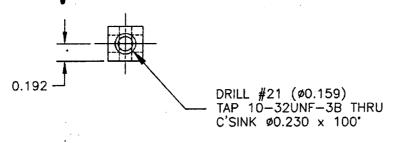




	DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
	CHEC	KED APPROVED	DRAWING NO.	REV. A		
	·	# #	D3257	SHEET 1 OF 1		
	DATE		TITLE	SCALE		
	04.0	01.27	FITTING	1:1.		
	Α	04.01.27	NEW ISSUE			
-	A١	- 14 04.12.14	ADD TOLERANCE			







D3257-1 FITTING

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

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